

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019617**Date Inspected:** 30-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013M-167 [RS3434A stiffener to RS3433D stiffener on Side Panel (SP) 3099A, complete joint penetration (CJP) weld at Panel Point (PP) 118.35]. The welder is identified as 067707 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

The SMAW process on weld joint no: SEG3013E-116 (RS3428E stiffener on SP3090E to Sub Assembly; SA3159A, CJP weld; with backing; at PP119.65). The welder is identified as 066261 and was observed welding in

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the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2a-1.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020AL-005 [SP3141C to Floor beam (FB) 3321A, CJP weld at PP126]. The welder is identified as 067609 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 18585 Rev-0.

Repair welding of weld joint no: SEG3020E-056 [Bottom Plate (BP) 3093A to FB3343A, CJP weld at PP128.3]. The welder is identified as 066398 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2734 Rev-1.

Repair welding of weld joint no: SEG3020D-052 (BP3092A to FB3343A, CJP weld at PP128.3). The welder is identified as 066038 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR Report: B-CWR 2734 Rev-1.

The SMAW process on weld joint no: DP3169-001-243 [DP3169A to RS stiffener, partial joint penetration (PJP) weld]. The welder is identified as 037779 and was observed welding in the 2G position. ABF QA was identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
